

Date: Friday, 9/15/2006 11:56:24 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRAME WELDMENT	
Job Number	: 28612		Part Number	: D3330041	
Estimate Number	: 11202		Drawing Number	: D3330 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/15/2006 S.O. No. : N/A		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : LARGE FAB ASSY		Due Date	: 10/5/2006 Qty: 2 Um: Each	
Previous Run	: 23016				
Written By					
Checked & Approved By					
Comment	: Est. A05.01/13 New Issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33301	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-1 Panel B22258	
2.0	D33302	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-2 Panel B28624	
3.0	D33303	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-3 Panel B28625	
4.0	D33305	Rail	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Rail Pick: Qty Part Number Description Batch 1 D3330-5 Panel B28626	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:56:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28612

Part Number: D3330041

Job Number:



Seq. #:	Machine Or Operation:			Description :
5.0	D33307		Panel	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	Panel	Pick:	
✓	Qty Part Number Description Batch	1 D3330-7 Panel	B28627	CPL 06-10-26 ②
6.0	D33309		Top Plate	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	Top Plate	Pick:	
✓	Qty Part Number Description Batch	1 D3330-9 Panel	328628	CPL 06-10-26 ②
7.0	D333011		Long Pin Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	Long Pin Bracket	Pick:	
✓	Qty Part Number Description Batch	1 D3330-11 Long Pin Bracket	323590	CPL 06-10-26 ②
8.0	D333013		Short Pin Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	Short Pin Bracket	Pick:	
✓	Qty Part Number Description Batch	1 D3330-13 Short Pin Bracket	323044	CPL 06-10-26 ②
9.0	D333015		Handle	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	Handle	Pick:	
✓	Qty Part Number Description Batch	1 D3330-15 Handle	B28623	CPL 06-10-26 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:56:25 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28612

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D333017 Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Socket

Pick:

✓ Qty Part Number Description Batch
1 D3330-17 Handle Socket B23047

PPL 06-10-26 ②

11.0 D333019 Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Rim

Pick:

✓ Qty Part Number Description Batch
1 D3330-19 Handle Rim B23048

PPL 06-10-26 ②

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

PPL 06-10-30 ②

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

11/06/10/30 ②

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Q.M 06/11/06 ②

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/06/10/07 ②

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Storage

11/06/11/07 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 06/11/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:56:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28612

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



@

Comment: FINAL INSPECTION/W/O RELEASE

10611107

Job Completion



10611107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

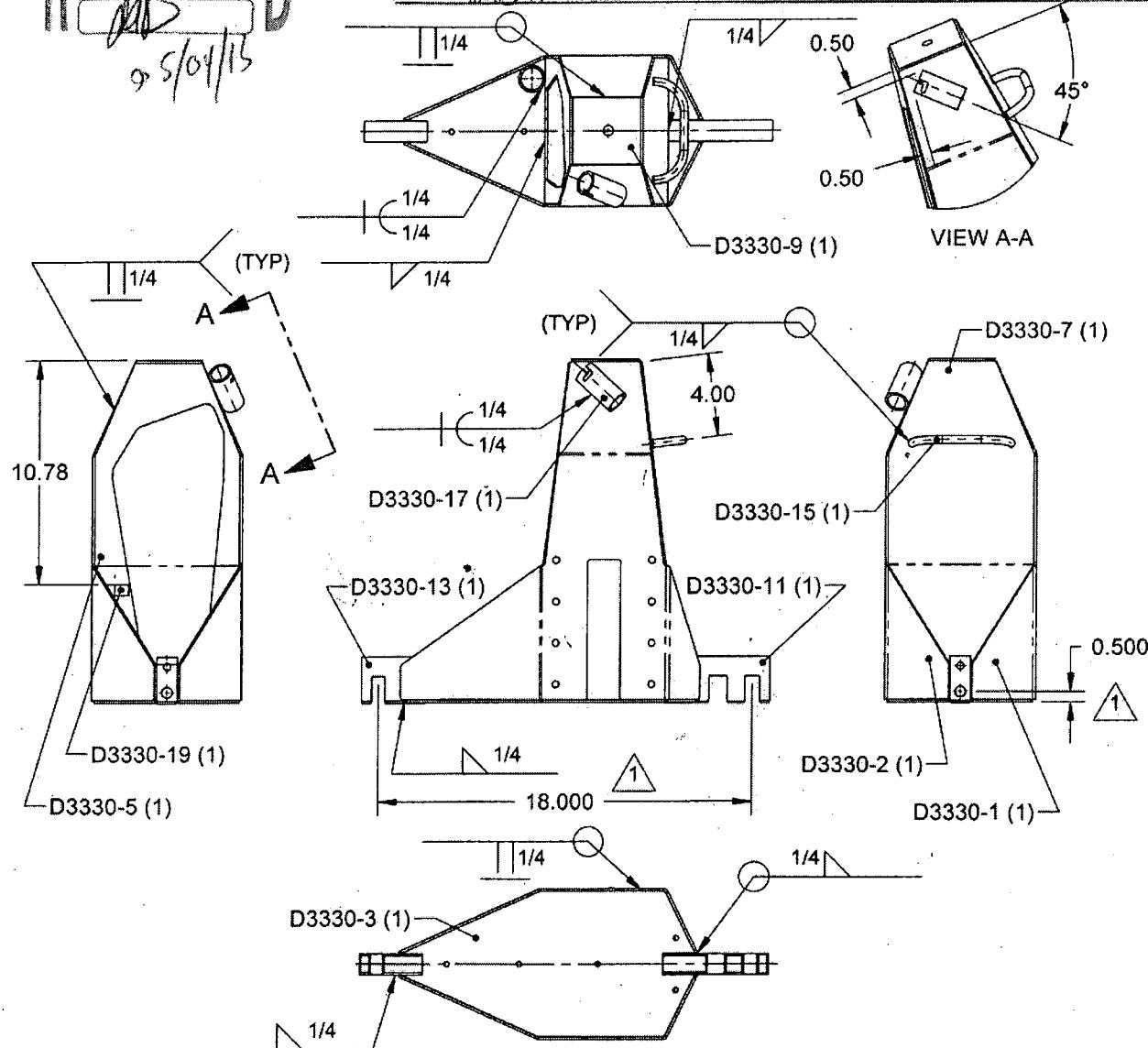
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>BS</i>	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26	TITLE FRAME WELDMENT	SCALE 1:8	

RELEASED
S/01/15



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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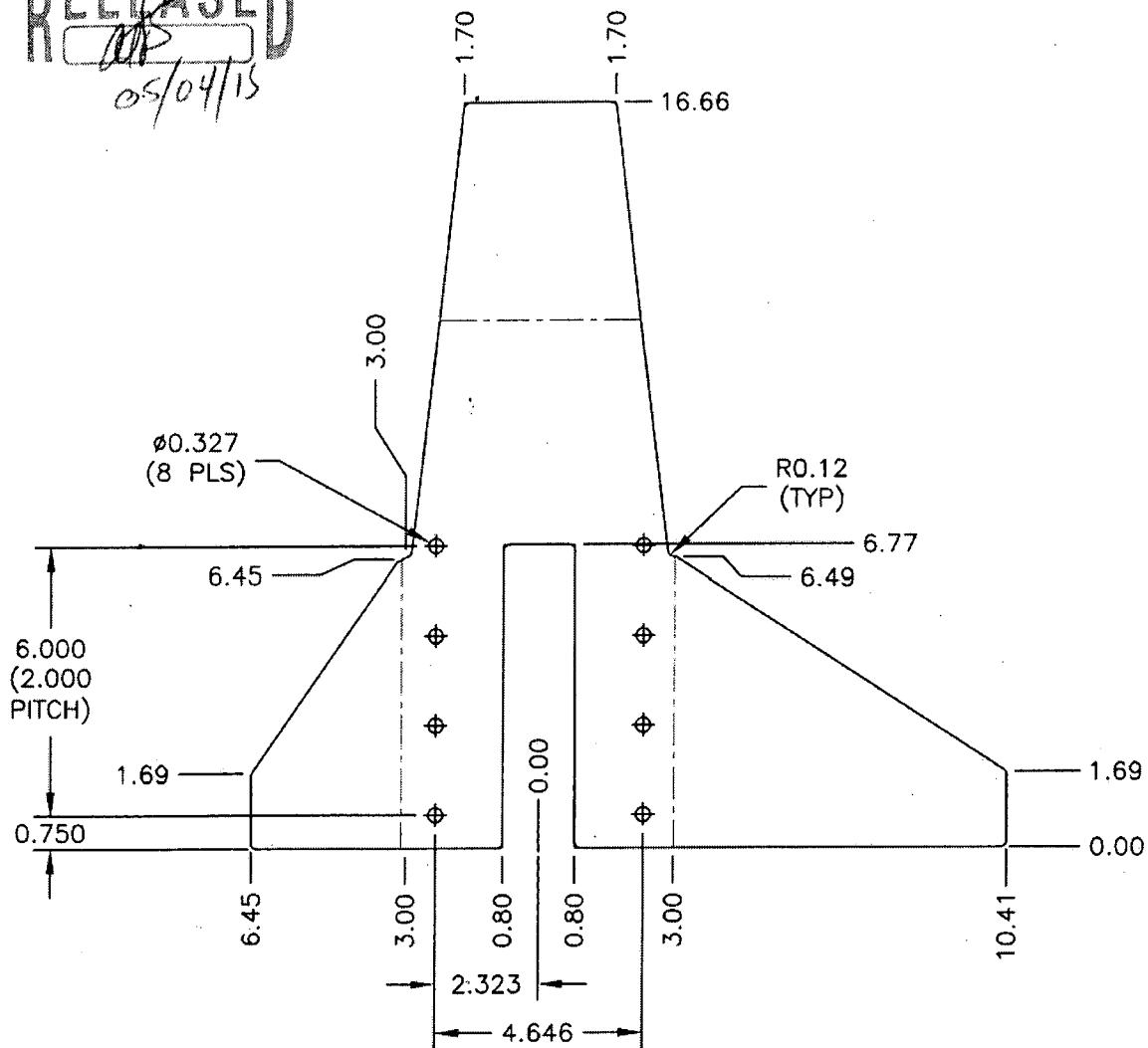
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WORK ORDER
NO. 28612



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DATE	05.02.26	TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
DP
05/04/15



D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

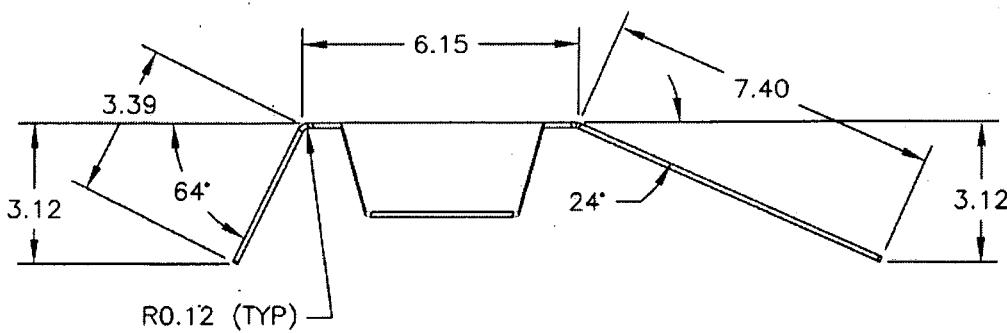
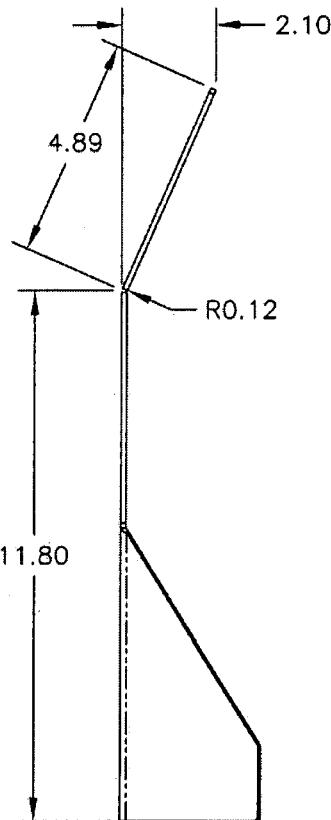
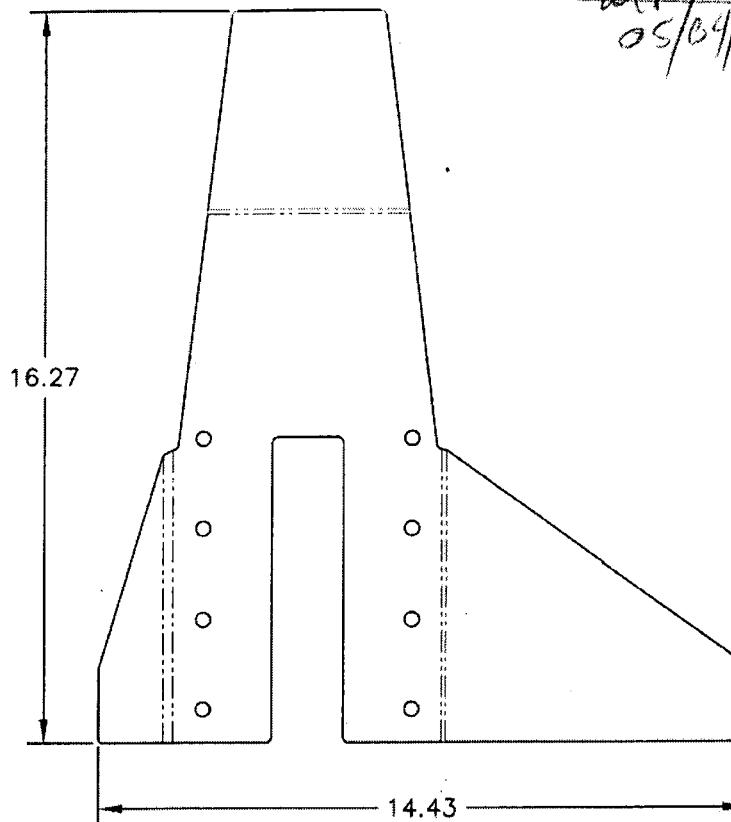
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		D3330	SHEET 3 OF 9
DATE	TITLE	SCALE	
05.02.26	FRAME WELDMENT	1:4	

RELEASED
05/04/15



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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WORK ORDER
NO. 28612

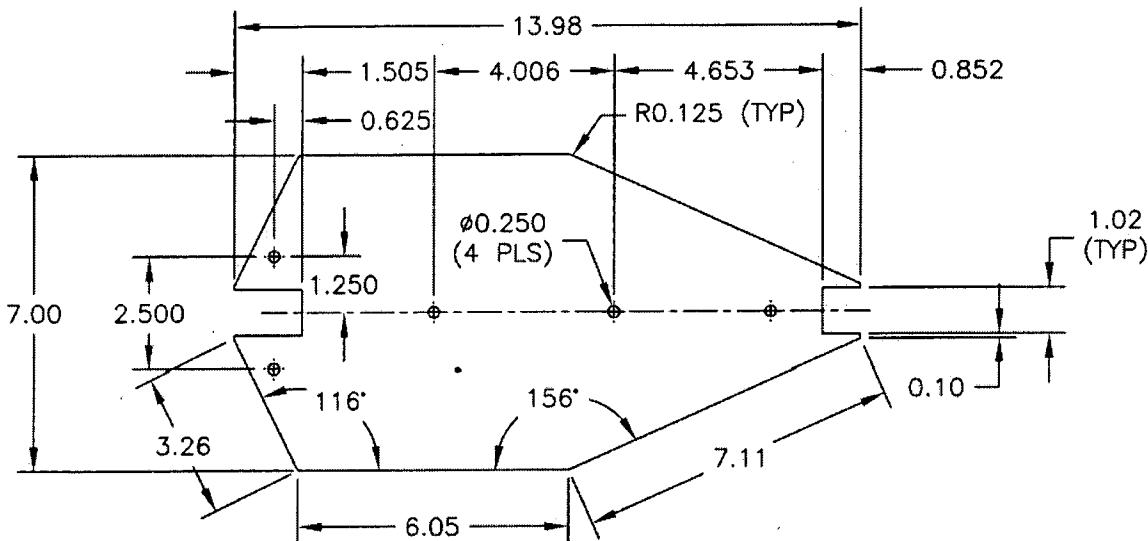
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
AB
05/07/15

**D3330-3 PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
NOTICE
UNCONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WORK ORDER
- 3) ALL DIMENSIONS ARE IN INCHES
NO. *28612*
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

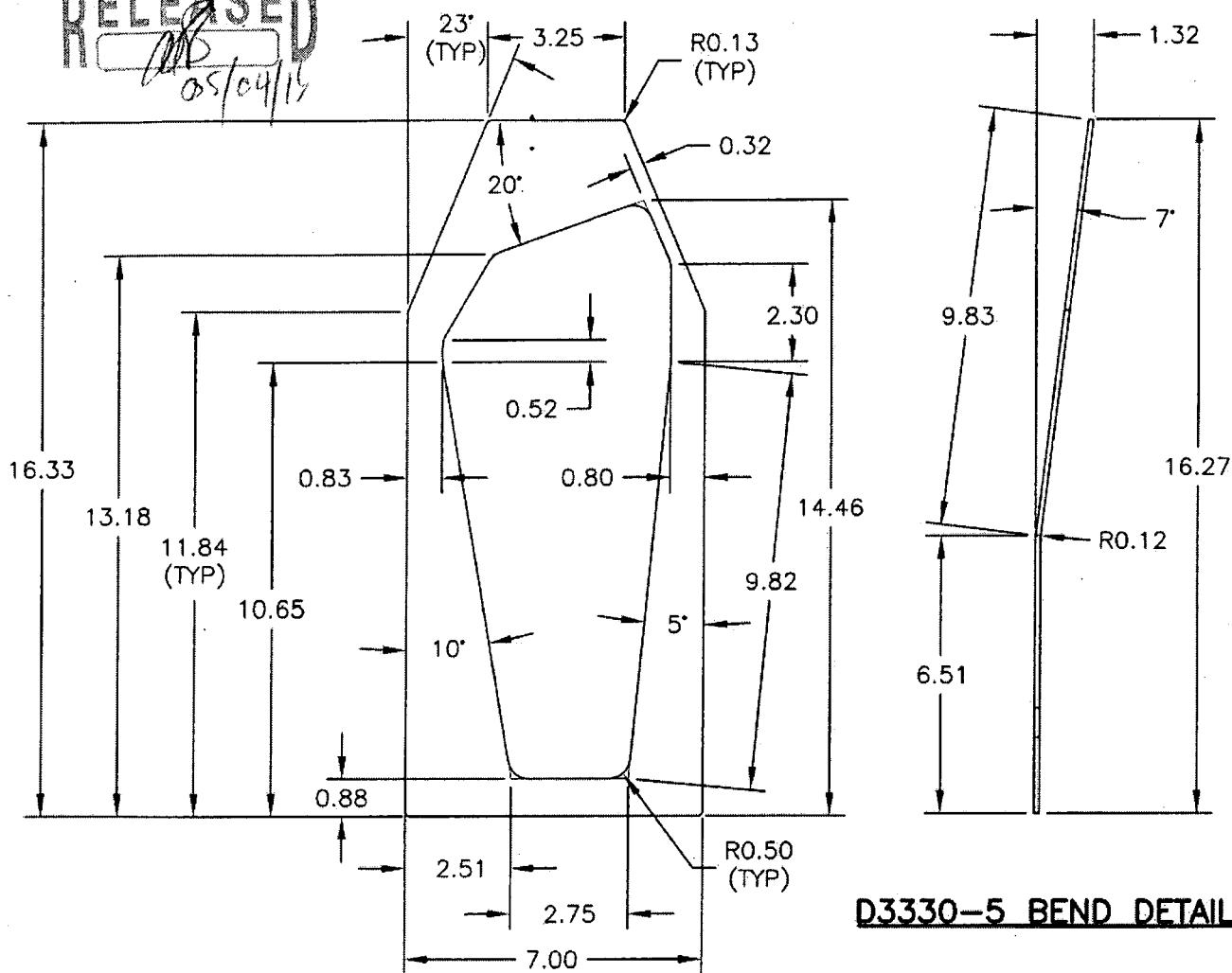
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EFFECT TO AMENDMENT
NOTICE
WORK ORDER
NO. *28612*



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		D3330	SHEET 5 OF 9
DATE	TITLE	SCALE	1:4
05.02.26	FRAME WELDMENT		

RELEASED
MD
05/04/15



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-2 ENGINEERING 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 IN THICK) SOLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 3) ALL DIMENSIONS ARE IN INCHES WITHOUT NOTICE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER

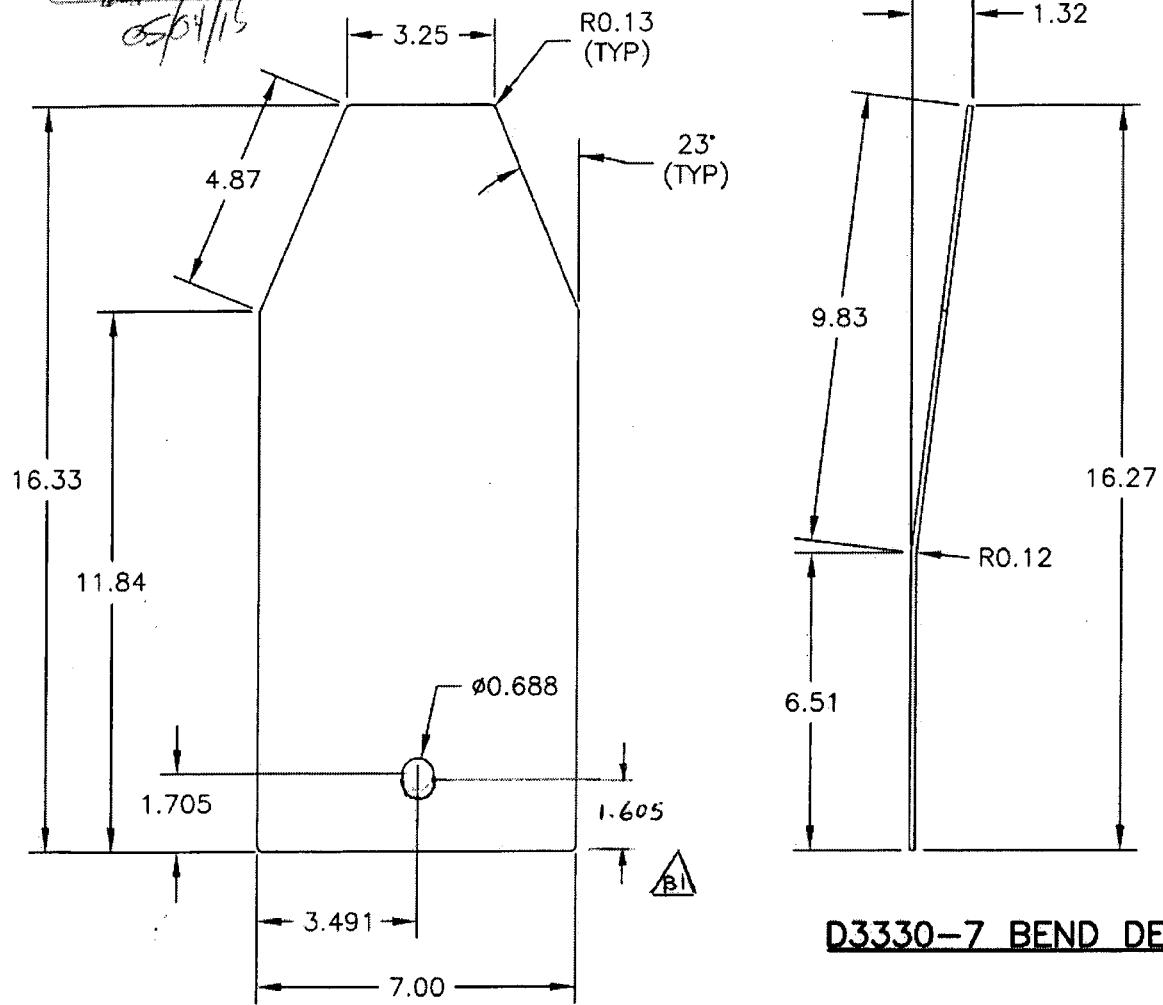
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DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

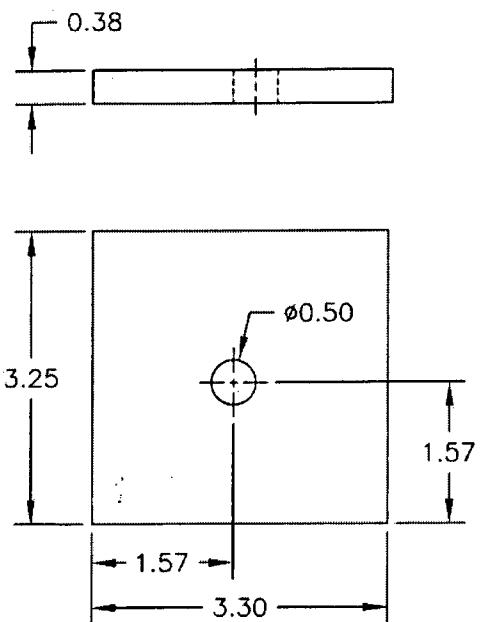
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ESP/13**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-20 CONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) TO AMENDMENT
SUBSTITUTE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WITHOUT NOTICE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
WORK ORDER
NO. 28612

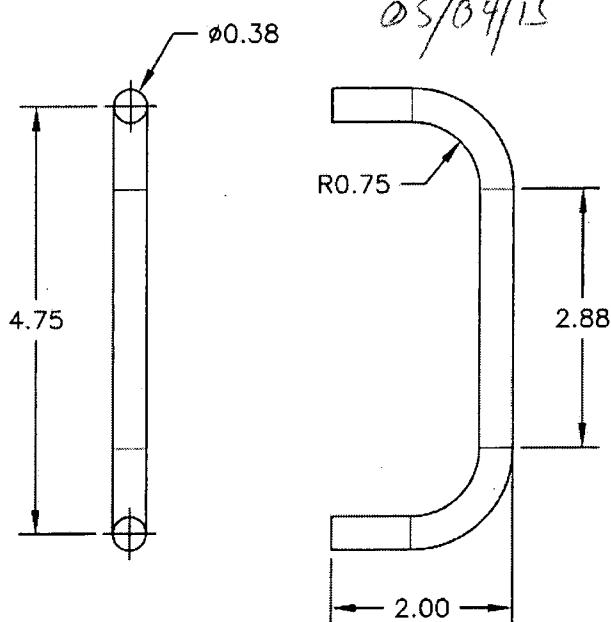
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:2



⚠ D3330-9 TOP PLATE



⚠ D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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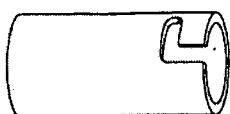
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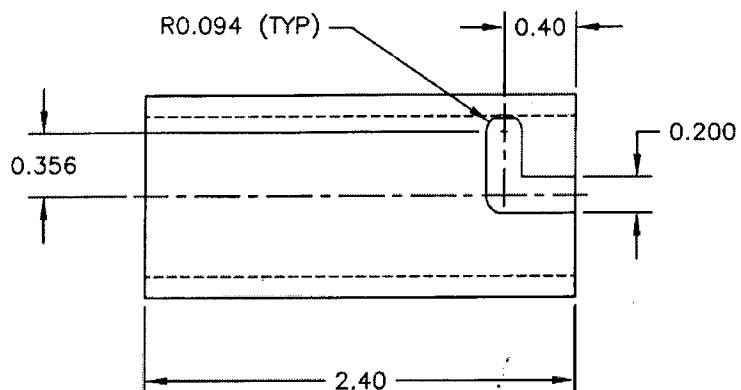
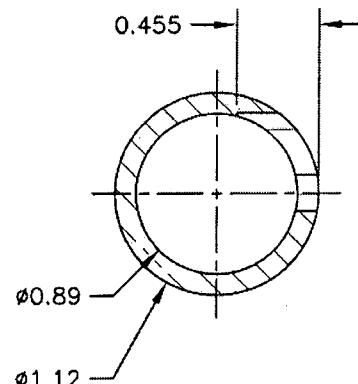
NO. *28612*

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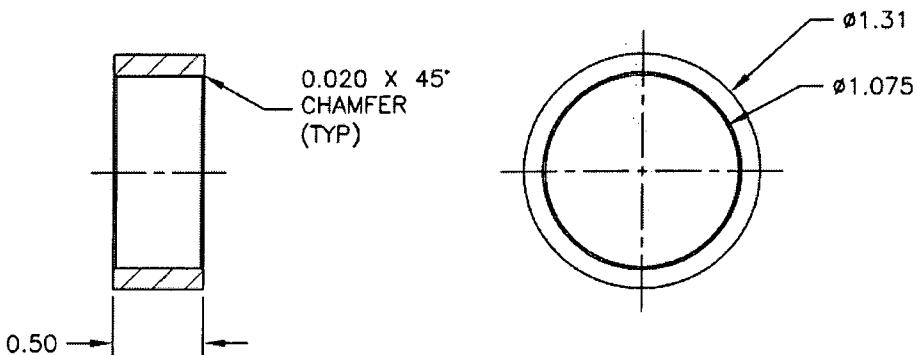
DESIGN <i>13</i>	DRAWN BY <i>SB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BT</i>	APPROVED <i>MM</i>	DRAWING NO. D3330	REV. B SHEET 8 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1



A →

**RELEASED**
MB 05/02/05

A →

SECTION A-AD3330-17 HANDLE SOCKETD3330-19 HANDLE RIMNOTES:

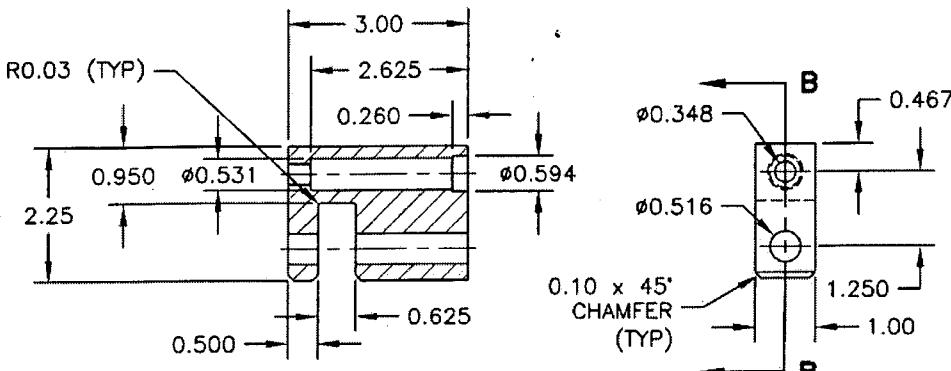
- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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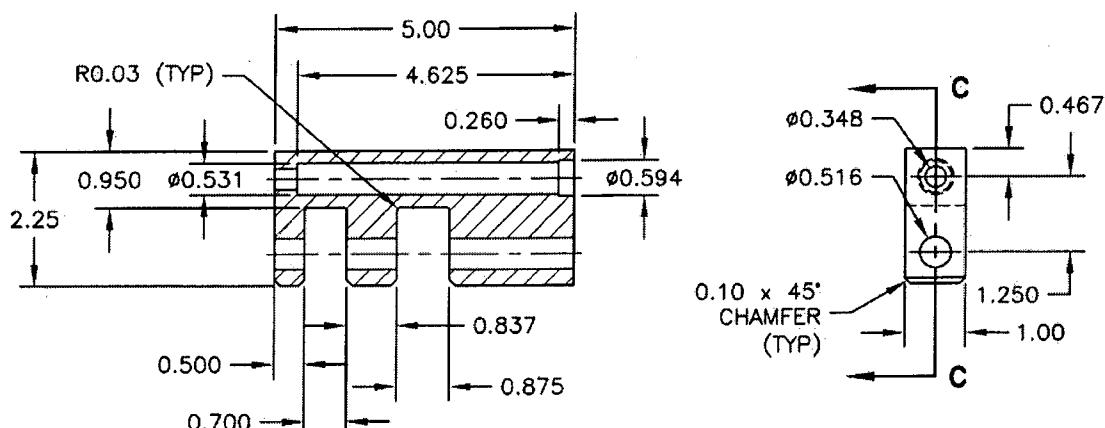


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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. B
		D3330	SHEET 9 OF 9
DATE	TITLE	SCALE	
05.02.26	FRAME WELDMENT	1:3	



RELEASED
APP
05/04/15.

D3330-13 SHORT PIN BRACKET



D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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